

WHAT IS CLAIMED IS:

1. A combination, comprising:  
a foam insert having a surface;  
a woven material disposed at the surface of the foam insert;  
a fabric sewn onto the foam insert by a plurality of stitches  
which extend through the woven material.
2. The combination of claim 1, wherein the foam insert has an outer surface and an inner surface and the woven material is disposed at the inner surface of the foam insert.
3. The combination of claim 2, wherein the foam insert is a molded insert and the outer surface is in the form of a face.
4. The combination of claim 2, wherein the inner surface of the foam insert is concave.
5. The combination of claim 1, wherein the fabric is stitched to a surface of the insert opposite the surface at which the woven material is disposed.
6. The combination of claim 1, wherein the woven material is a fabric mesh.
7. The combination of claim 6, wherein the surface of the foam insert to which the fabric is stitched has a skin.

8. The combination of claim 1, wherein the foam insert is a polyurethane foam and the woven material is heat bonded to a surface of the polyurethane foam.

9. The combination of claim 8, wherein the foam insert is a molded insert and has an outer surface and a concave inner surface, the outer surface is in the form of a face, the outer surface has a skin and wherein the woven material is disposed at a portion of the inner concave surface of the foam insert.

10. The combination of claim 9, wherein the woven material is a fabric mesh, and wherein stitches extend through the fabric, the skin, the polyurethane foam stuffing, and the fabric mesh.

11. A doll comprising:  
a doll head having a surface and comprising a foam insert;  
a doll body; and  
a mesh coupled to the surface of the doll head;  
wherein the doll body is coupled to the doll head by stitches which extend through the mesh.

12. The combination of claim 10, wherein the foam insert has an outer surface and an inner surface and the mesh is coupled to the inner surface of the foam insert.

13. The combination of claim 12, wherein the foam insert is a molded insert.

14. The combination of claim 12, wherein the inner surface of the foam insert is partially concave and the mesh is disposed at the inner concave surface of the insert.

15. The combination of claim 14, wherein the outer surface of the insert is skinned.

16. The combination of claim 15, wherein the foam insert is a polyurethane foam and the woven material is heat bonded to a surface of the polyurethane foam.

17. The combination of claim 16, wherein the doll body is disposed against the skinned surface of the insert.

18. The combination of claim 17, wherein the stitches extend through the doll head, the skinned surface, the insert and the woven material.

19. The combination of claim 11, wherein the mesh is a fabric mesh.

20. A process for attaching a doll head to a doll body, comprising:  
providing a doll head comprising a foam insert having a skinned outer surface and an inner surface,

positioning a part of a doll body adjacent the skinned surface of the doll head and a woven material adjacent at least a portion of the inner surface of the doll head; and

sewing said part of the doll body to the doll head by passing stitches through said part, the skinned surface, the foam insert and the woven material.